

Work Order ID 78508

78508

Page 1

January-10-12 1:18:36 PM

Item ID: D4308-042

Accept

Revision ID:

Item Name: Step, RH Crew

Start Date: 1/10/12 Start Qty: 3.00

Required Date: 1/13/12 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4308	A

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D4308-1 using D2622 extrusion as per Dwg D4308
2-Drill, c'sink one hole on top of step as per dwg
3-Deburr and bevel ends for welding

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

120

Weld per dwg A/R Aluminum rod Batch: 114514 0.00

120

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld end cap (ONE END ONLY)
2-Grind end cap welds flush
3-weld lugs as per Dwg D4308

12.01.10 3

12.01.10 3x

12.01.11 1

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Item ID: D4308-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step, RH Crew

Start Date: 1/10/12 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

3 8 BE12-01-11

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

8 12/01/11

13

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

12-01-11

3 8

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Accept

Setup Start

NS1

Stop

NS2

Start Date: 1/10/12 **Start Qty:** 3.00

3

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 3.00

3

Customer:

Reference:

Run Start

NR1

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:**SPC (Y/N):**

Date:

[illegible]

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Item ID: D4308-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step, RH Crew

Start Date: 1/10/12 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 QC5- Inspect part completeness to step on W/O

0.00

190

0.00 8/21/12

QC

Memo

Quality Control

200 Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.00

Hand Finishing

210 211 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

210

Powdercoat

Memo

0.00

Powder Coating

Prime M 117319

Delteet Blue M 118395

den Delteet M 118093

12.01.12 (3)

12.01.23 (3)

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Item ID: D4308-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step, RH Crew

Start Date: 1/10/12

Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/13/12

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

211

QC3- Inspect Part Finish

0.00

211

QC

Quality Control

QC 14
Memo

① 12-01-24

215

Wing Walk as per dwg QSI005 4.4 Batch 120105 0.00

215

HandFinish

Hand Finishing

Memo

0.00

3 12-1-25

220

QC3- Inspect Part Finish

0.00

220

QC

Quality Control

Memo

0.00

3 12-1-27

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Item ID: D4308-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step, RH Crew

Start Date: 1/10/12

Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/13/12

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

Identify as per dwg & Stock Location: _____

0.00

230

Packaging

Memo

0.00

Packaging

12/1/25 12/3

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

12/1/25 12/3
MF
12-01-25

Picklist Print

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Work Order ID: 78508

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

Start Date: 1/10/12

Required Date: 1/13/12

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 11.01.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	54.6200	0.05	0.15		12.01.11	

Location	Loc Qty	Loc Code
HALL	16.62	
46910	2	
64409	6	
66970	7.7	
68293	0.5	
72131	0.42	0.15
WA013	38	
75781	38	

D2734
Step End Plate

Manufactured No 120 Each 144.0000 1 3

12.01.11

Location	Loc Qty	Loc Code
WA	135	
76985	135	
WA015	9	
73416	9	3

D2734
Step End Plate

Manufactured No 170 Each 144.0000 1 3

12.01.12

Location	Loc Qty	Loc Code
WA	135	
76985	135	1
WA015	9	
73416	9	2

Picklist Print

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Work Order ID: 78508
Parent Item: D4308-042
Parent Item Name: Step, RH Crew

Start Date: 1/10/12

Required Date: 1/13/12

Start Qty: 3.00

Required Qty: 3.00

D3458-1
Step Mounting Plate

Manufactured No

120 Each 22.0000

1 3 *12.01.11*

Location

Loc Qty

Loc Code

WA002

21

75609

21

3

WA018

1

63075

1

3

D3458-3
Step Mounting Plate

Manufactured No

120 Each 32.0000

1 3 *12.01.11*

Location

Loc Qty

Loc Code

WA002

32

75610

32

3

MS20601-AD4W2
Rivet

Purchased No

170 Each 176.0000

1 3 *12.01.11*

Location

Loc Qty

Loc Code

ST322

176

119232

176

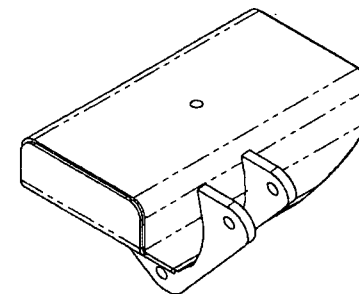
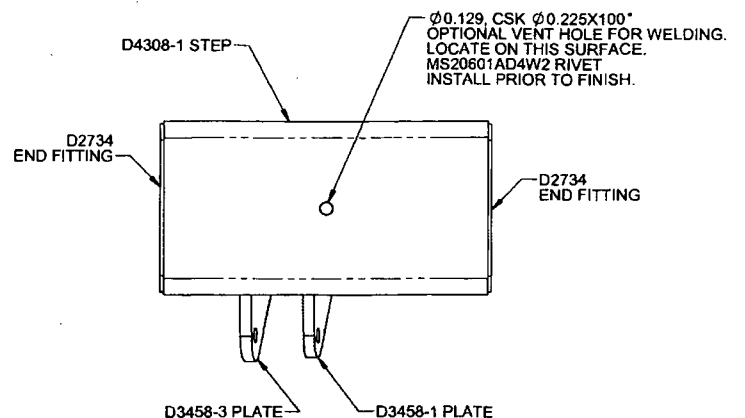
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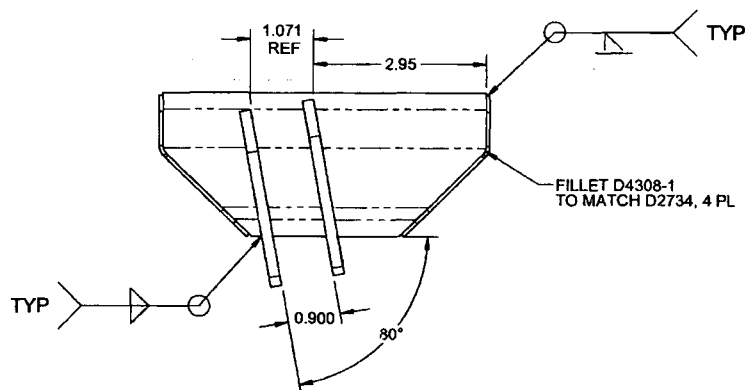
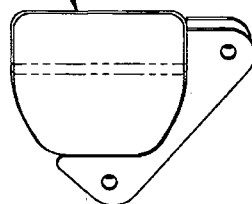
Shop Packet Print

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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-041 STEP, LH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

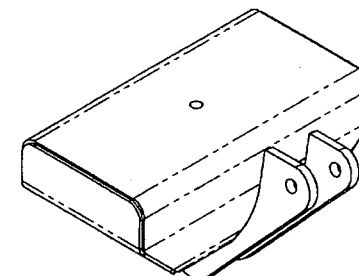
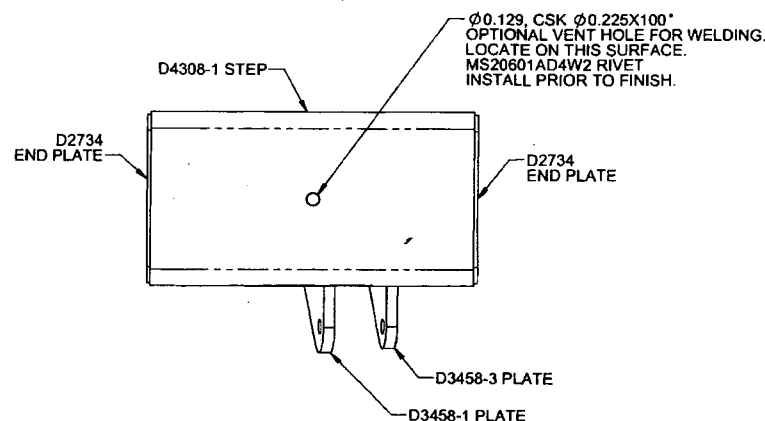
WFO 78808

RELEASED
2011-05-26
WFO

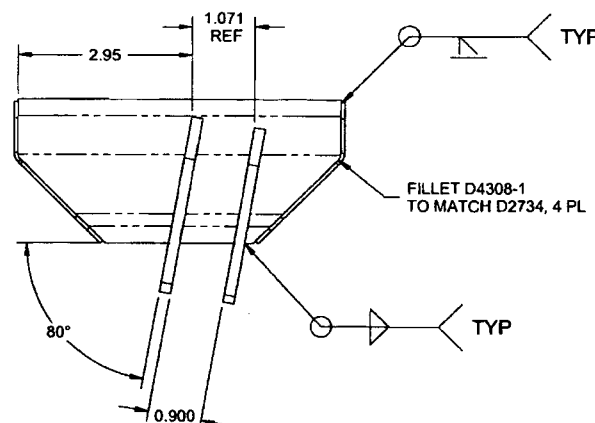
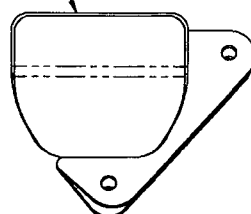
REV.	NEW ISSUE	DESCRIPTION	CP	10.12.17
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.12.17			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4308	REV. A
TITLE STEP, CREW	SHEET 1 OF 3
SCALE NTS	
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ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)








2) APPLY BLACK
ANTI-SKID ON TOP
SURFACE TO BOTTOM
OF TOP RADIUS



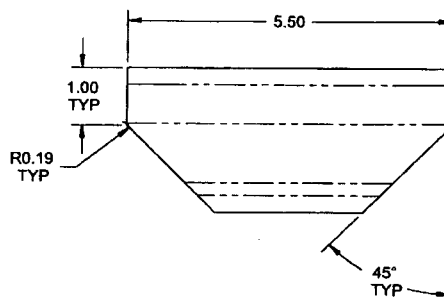
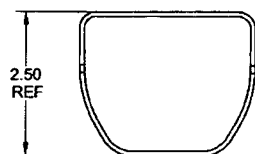
D4308-042 STEP, RH CREW

NOTES:

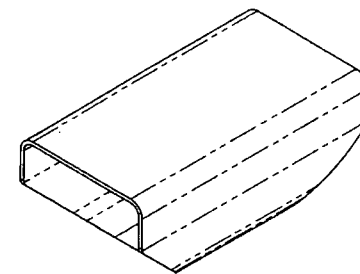
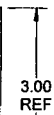
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D4308	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
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RELEASED
2011-05-24



D4308-1 STEP



NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

RELEASED
2011-05-23
JMO

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D4308	REV. A
MFG. APPR.	AD	SHEET 3 OF 3	
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	STEP, CREW	NTS
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